

Work Order ID 55352

January 13, 2010 1:21:08 PM

Page 1

Item ID: D2647

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 1/13/10 Start Qty: 20.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2647

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2647 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

1810-1-13

96

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1810-1-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 S10101/14


centis.
95

φ

Ph →

W/O: 55352

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|---------|------|--|----|---------|-----|---|--------------------------|
| 10/1/14 | #120 | Took Qty & Part For QC inspection template | S | 10/1/14 | 1 |  | S 10/1/14 |
| | | | | | | | |

Part No: D2647 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Item ID: D2647

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 1/13/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 Small Fab | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Debur | 0.00 | | | | | | | |
| 140 QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |
| 150 Packaging | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |

P 1/14/14 (96)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D2647

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 1/13/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15 *[Signature]*
MF
10-1-14

Picklist Print

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Page 1

Work Order ID: 55352

Parent Item: D2647

Parent Item Name: Cap

Comments: IPP Rev:DU99.01.25 Re-format DM
IPP: E 06.11.15 waterjet EC

Start Date: 1/13/10

Required Date: 1/15/10

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.080 | | Purchased | No | | | 100 | sf | 207.0597 | 3.3621 | 16 | | |



6061-T6 .080 Sheet



B.10-1-13

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 207.05967 | |
| 110630 | 35.0136 | |
| 112141 | 0.86727 | |
| 112763 | 6.85 | |
| 113438 | 164.3288 | |

90

113438

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

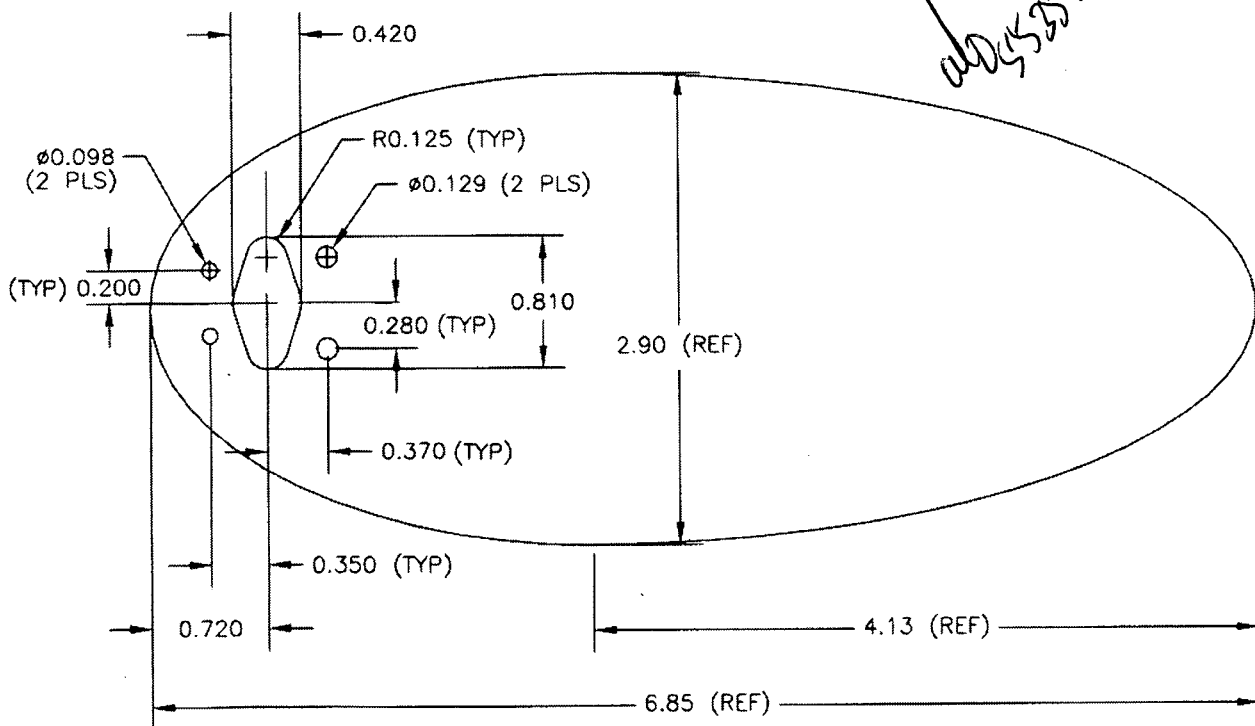
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY KT | DART AEROSPACE USA, INC. BELLEVUE, WA | |
| CHECKED # | APPROVED # | DRAWING NO. D2647 | REV. F SHEET 1 OF 1 |
| DATE 00.05.26 | | TITLE CAP | SCALE NTS |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.27 | CHANGED SHAPE | |
| C | 97.09.15 | REMOVE FRONT PLATE | |
| D | 97.11.06 | ADD RIVET HOLES | |
| E | 98.01.15 | ADD 5052 MATERIAL (TSR A245) | |
| F | 00.05.26 | MAKE FROM D2794 | |



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR
5052-H32 (QQ-A-250/8) 0.080 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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